

Date: Wednesday, 1/11/2006 4:18:05 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID
Job Number	: 25438B		
Estimate Number	: 10193		
P.O. Number	: N/A	Part Number	: D2512
This Issue	: 1/11/2006 S.O. No. : N/A	Drawing Number	: D2512 REV D4 D2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: D4 D2
Previous Run	: 25436B	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 1/26/2006
Checked & Approved By	: SEE ABOVE USER & DATE	Qty:	1 Um: Each
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 30.4931 f(s)/Unit Total : 30.4931 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: M100023

AA 06/02/13

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3166-3 Basket Hoop

Batch

B25508

AA 06/02/13

3.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2506 Label Plate

Batch

B24875

AA 06/02/20

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2327-1 Bushing

Batch

B24873

AA 06/02/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:18:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 25438B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

B23445

AA 06/02/20

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B25139

AA 06/02/20

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M100071

AA 06/02/20

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-D2012-117 is included in D3172-041 EC130 Basket Base BOM.  
EC130 Basket only

Pick:

Qty Part Number

Description

Batch

2 D2012-117 Clevis

AA 06/02/20

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 12 Date: 06/03/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:18:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 25438B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DD 06-02-20

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ml 06 03 02

①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

SPRAY 19640

Batch: m10037

ml 06 03 03 ①

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-03-06  
06/03/07 ①

Job Completion



U 06-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

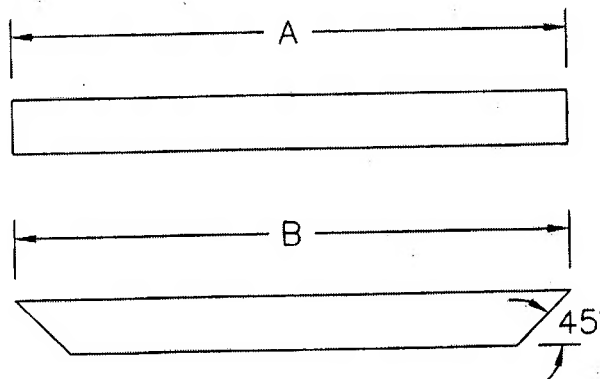


DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	
A		95.11.21	NEW ISSUE
B		96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C		99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D		01.04.19	CHANGE HINGE
D1		UP 03.01.20	ADD D2012-117 FOR D130-701-041
D2		UP 04.09.20	TACK WELD ANT-SKID AREA

RELEASED  
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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WITH YOUR NOTICE

WORK ORDER  
NO. 25438B

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

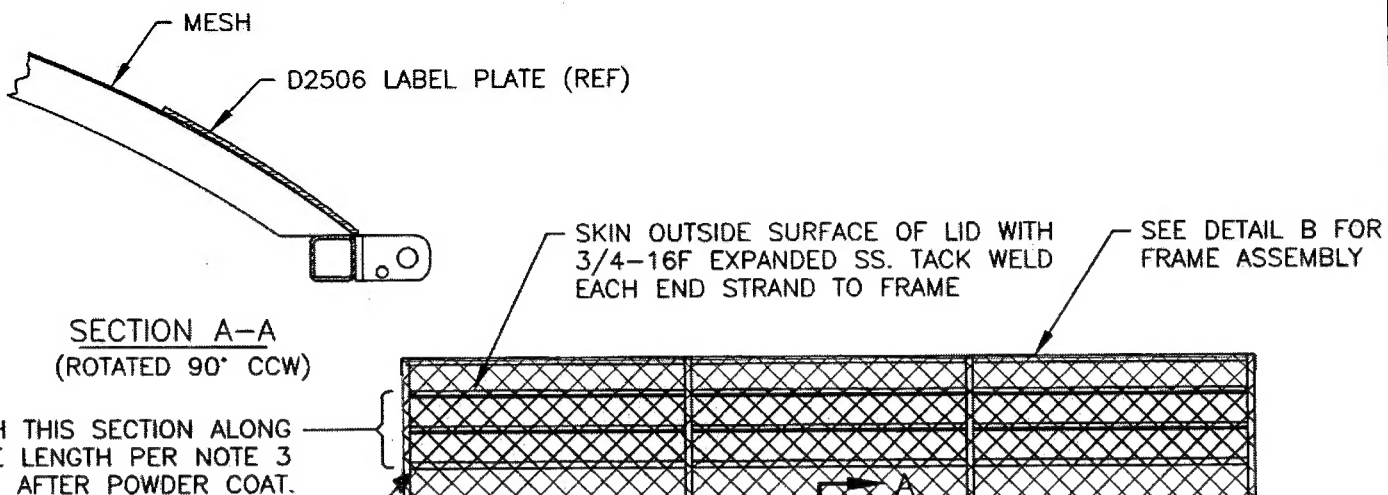
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**DART**



DESIGN	BW	DRAWN BY	<i>CS</i>	<b>DART AEROSPACE LTD</b>
CHECKED	<i>CS</i>	APPROVED	<i>CS</i>	HAWKESBURY, ONTARIO, CANADA
DATE	01.04.19	DRAWING NO.	D2512	REV. D
		TITLE	BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4
				SCALE 1:20



**TACK WELD MESH TO FRAME**  
**AT EVERY AVAILABLE LOCATION**  
**IN AREA TO BE ANTI-SKIDDED**

SHOP COPY  
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SUBJECT TO  
WITH OUT  
W/O CONTROL  
NO. 25438B

**RELEASED**  
01.04.21

**D2512 BASKET LID ASSEMBLY**

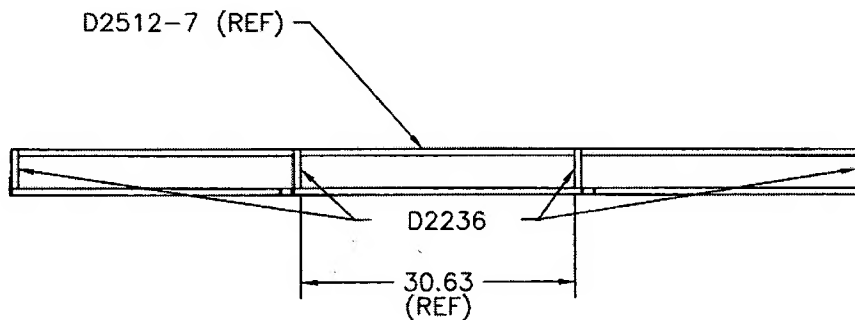
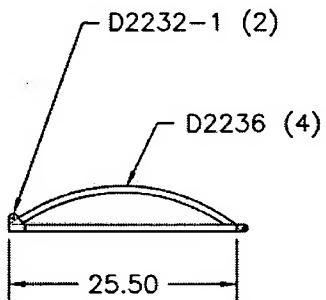
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



**DART**



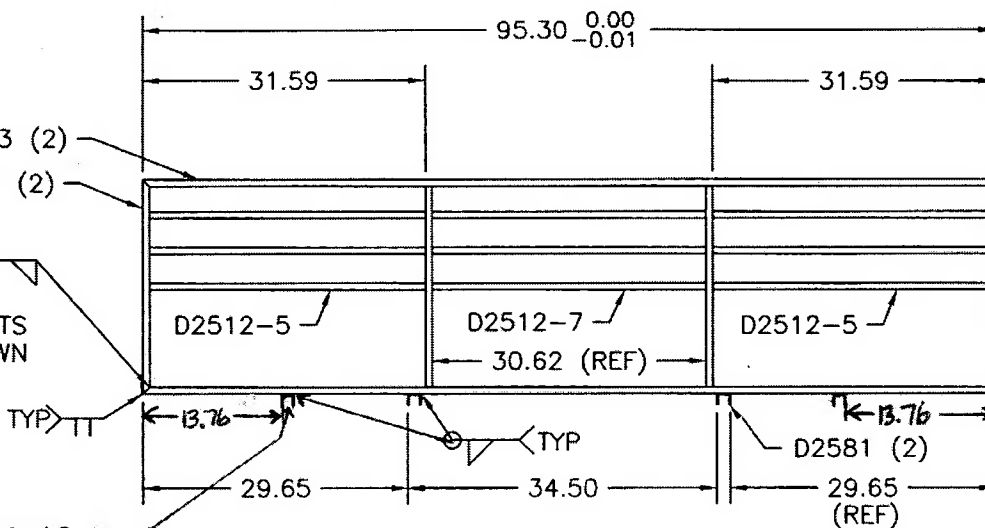
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	UP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2512
DATE	TITLE	REV. D
01.04.19	BASKET LID ASSEMBLY (350/212)	SHEET 3 OF 4
		SCALE 1:20



UNCONTROLLED  
SUBJECT TO  
WITH NO  
JFENT  
WELD  
ALL JOINTS  
AS SHOWN

STAMPED  
D2512-3 (2)  
D2512-1 (2)  
TYP

WORK ORDER  
NO 25438B



DI  
D2012-117 CLEMS  
ADD FOR D130-701-041  
ONLY (2 PLACES)

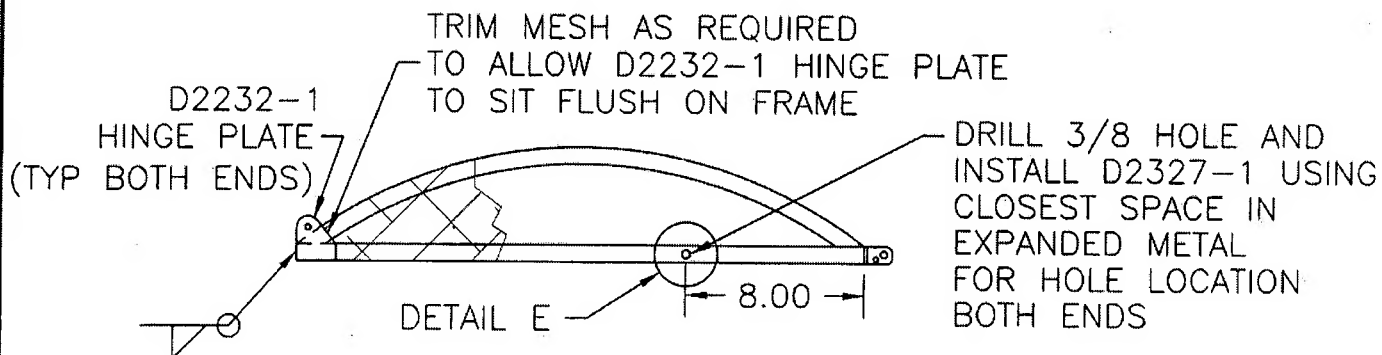
DETAIL B  
FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

RELEASED  
01.04.27

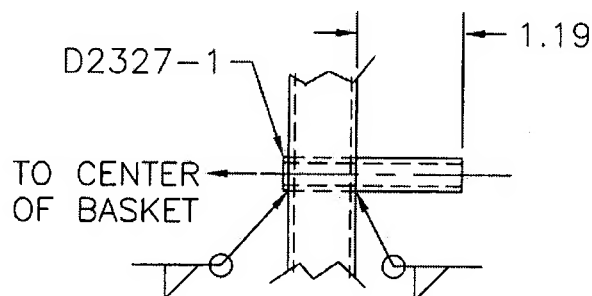




DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



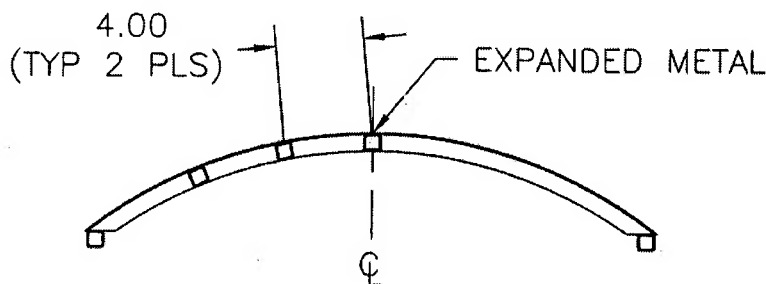
SECTION C-C SIMILIAR BOTH END RIBS



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WORK ORDER  
NO. 25438B



SECTION D-D SAME BOTH CENTER RIBS

RELEASED  
01.04.27

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Date: Wednesday, 1/11/2006 4:17:38 PM  
 User: Kim Johnston

## Process Sheet

4

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 25438  
 Estimate Number : 10197  
 P.O. Number :  
 This Issue : 1/11/2006 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : LARGE FAB ASSY  
 Previous Run : 25436  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:M 05.09.02 Added D2856-400-720 KJ/JLM

Drawing Name : HELI UTILITY BASKET LH/RH  
 Part Number : D350607041  
 Drawing Number : UNDER REVIEW D350-607 Rev.F  
 Project Number : N/A  
 Drawing Revision : F  
 Material :  
 Due Date : 1/26/2006 Qty: 1 Um: Each  
 P06.01.12

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	25438A	BASKET BASE ASSEMBLY (350)



Comment: Sub-Component BASKET BASE ASSEMBLY (350)

2.0	25438B	350/212/130 BASKET LID
-----	--------	------------------------



Comment: Sub-Component 350/212/130 BASKET LID

3.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD350-607-041 CHG006

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D2022-101	Spacer	

6.0	D2258200	Weight Placard 200lb
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D2258-200	Label	

REFERENCE ONLY